

Date: Monday, 23/02/2009 3:29:03 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LATCH ASSEMBLY
Job Number : 45995	
Estimate Number : 13370	
P.O. Number :	Part Number : D3589041
This Issue : 23/02/2009 S.O. No. :	Drawing Number : D3589 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 44923	Material :
Written By :	Due Date : 15/03/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JD 09.02.24</u>	
Comment : Est Rev:A new issue 08-06-05 DD verified by:ec Est Rev:B 09-02-20 rev.b asper dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D35891	ARM
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

ARM

batch: B46189

PD 09-05-12

2.0	D35893	ARM GUIDE
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

ARM GUIDE

batch: B44942 → 4 B46101 → 12

PD 09-05-12

3.0	D35897	AFT GUIDE PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

AFT GUIDE PLATE

batch: B46194

PD 09-05-12

4.0	D35899	FWD GUIDE PLATE
-----	--------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

FWD GUIDE PLATE

batch: B44819 → 2 B46195 → 2

PD 09-05-12

5.0	D35891	FWD GUIDE PLATE
-----	--------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

FWD GUIDE PLATE

batch: B46190

PD 09-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/02/2009 3:29:03 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH ASSEMBLY

Job Number: 45995

Part Number: D3589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D358913

LUG



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

LUG

batch:

44945 → 2

B46191 → 6

09-05-12

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble and weld D3589-9 to D3589-11 as per dwg D3589

EXCHANGE D3589-11 AS FOLLOWS (IF NECESSARY): FROM 0.625" TO 0.750"

09-05-12

2- grind weld flush as per dwg D3589

3- slide (4) D3589-3 Arm Guides on D3589-1 Arm and weld D3589-13 lugs on both ends as per dwg D3589

*** ensure that the 4 ARM GUIDES are on the ARM before welding both LUGS***

4- using DT9033 jig install parts on door and weld as per dwg D3589 QSI004

ensure parts fit correctly on jig

304 Stainless Steel Rod Batch: M108160

PTC
M-1 09/05/13
09-05-12

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-05-12

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/13 (xy)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

11.0

AN960JD4

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

batch:

M11735

09/05/13 (y)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3589-041 PAR #: N/A Fault Category: Prod/FAB. L/S NCR: (Yes) No DQA: D Date: 05/05/20
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: AD Date: 09/05/20

NCR: <u>45995</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09-05-18</u>	<u>7.0</u>	<u>1x D3589-9 & 3x D3589-11 were scrap. Parts have to be ground according to fit + snug & they were grounded too much. 1x 11 was scrapped on drilling → The part buckled. R.C. process.</u>	<u>[Signature]</u> <u>05/05/20</u>	<u>scrap: no replace.</u>	<u>[Signature]</u> <u>09-05-18</u>	<u>[Signature]</u> <u>09-05-11</u>	<u>[Signature]</u> <u>05/05/20</u>	<u>[Signature]</u> <u>09-05-11</u>

NOTE: Date & initial all entries

Date: Monday, 23/02/2009 3:29:03 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH ASSEMBLY

Job Number: 45995

Part Number: D3589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D358915

LINK



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

LINK

batch: 44847 2P 46192 6X

LC

13.0

MS203921C7

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pin

batch: M108521

LC

14.0

MS246651010

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

COTTER PIN

batch: 111355

LC 9/5/13 (4)

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg D3589

8/5/09/05/14 (4)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/5/09/05/14 (4)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5139E

A 09-05-14 (4)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/14 (4)

Job Completion



MF 09-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

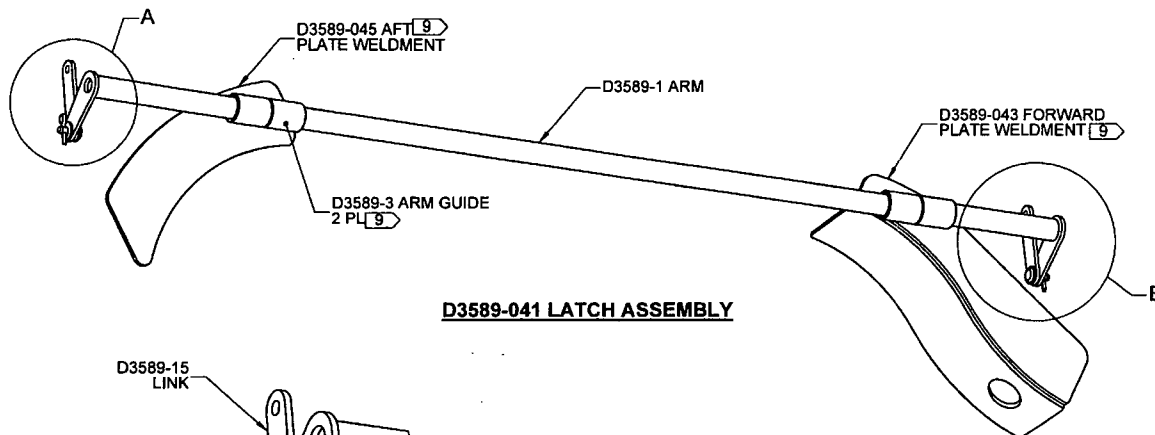
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

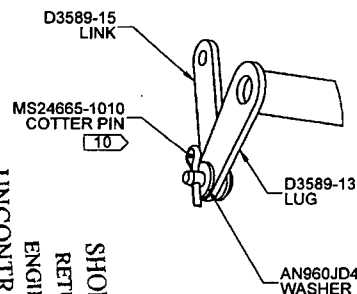
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

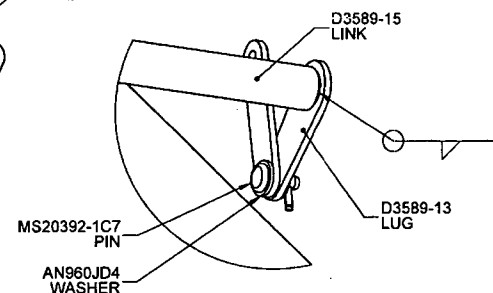
QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24685-1010	COTTER PIN



D3589-041 LATCH ASSEMBLY








DETAIL A: LINK ASSEMBLY DETAIL



DETAIL B: WELDING AND LINK ASSEMBLY DETAIL

SCALE 2X
2 PL

RELEASED
9/62/03 NHP

B	0.90 AND 0.83 REF WERE 1.87 AND 0.60 (ZN C3-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29" WAS 15" (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4). REDESIGNED D3589-9 (ZN A6-6) AND D3589-11 (ZN C2-3) REASON: REVISION FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION		MB	08.06.25
A	NEW ISSUE		MB	08.05.29
REV.	DESCRIPTION		BY	DATE
DESIGN	    	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		DRAWING NO. D3589		
CHECKED		TITLE LATCH ASSEMBLY		
MFG. APPR.		REV. SHEET 1 OF 1		
APPROVED		SCALE NT		
DE APPR.	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMERCIAL PURPOSES TO ANY OTHER PERSON OR ENTITY.			
DATE	08.06.25			

- D3589-041 NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI-018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 LBS
8) WELDING: PER DART QSI-004 USING DT9033
9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
10) INSTALL GOTTEN PIN IN ACCORDANCE WITH MS3540

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WORK ORDER
4NO 45945

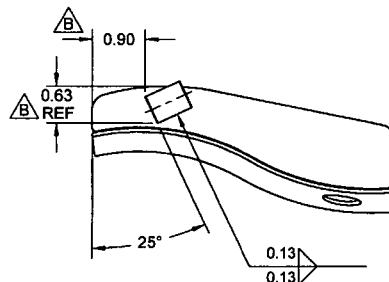
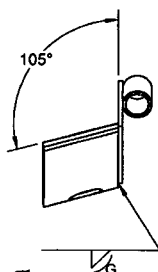
UNCONTROLLED COPY
SALES PERMITS
D35882-041 NOTES
1) MATERIAL N/A
2) FINISHES N/A
3) TOLERANCES PER DA
4) UNITS: INCHES UNITS
5) BREAK SHARP EDGES
6) IDENTIFICATION (BEN
7) WEIGHT: 0.73 lbs
8) WELDING: PER PART C
9) IDENTIFIED PARTS AR
10) INSTALL: BOTTOM RIN

QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
1	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE

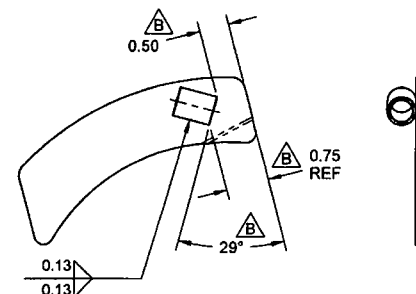
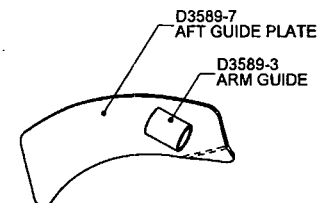
D3589-3
ARM GUIDE

D3589-9
FORWARD GUIDE PLATE

D3589-11
FORWARD GUIDE PLATE



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

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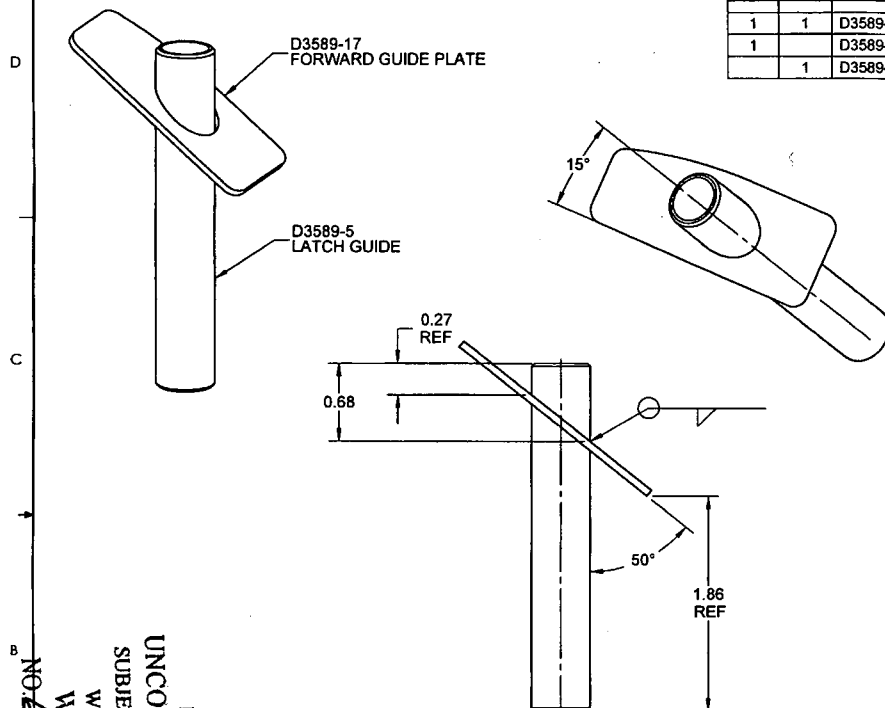
D3589-043/-045 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D3589-043 = 0.22 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

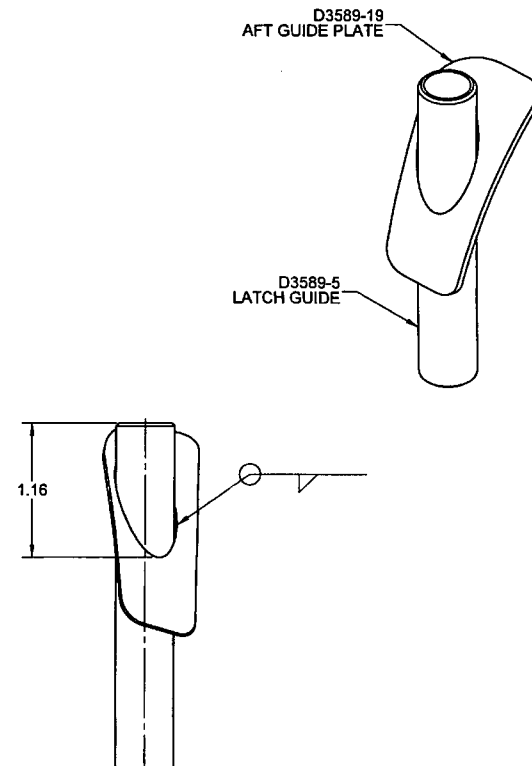
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3589 REV. B SHEET 2 OF 8 TITLE LATCH ASSEMBLY SCALE NTS
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED
09/07/25 N/A

QTY -047	QTY -049	P/N	DESCRIPTION
X		D3589-047	FORWARD GUIDE
	X	D3589-049	AFT GUIDE
1	1	D3589-5	LATCH GUIDE
1		D3589-17	FORWARD GUIDE PLATE
	1	D3589-19	AFT GUIDE PLATE



D3589-047 FORWARD GUIDE



D3589-049 AFT GUIDE

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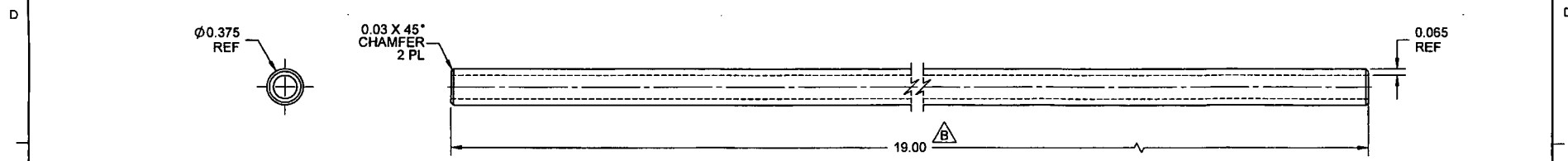
D3589-047/-049 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs EACH
- 8) WELDING: PER DART QSI 004

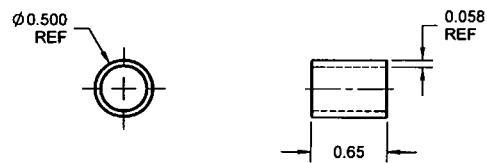
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3589	REV. B
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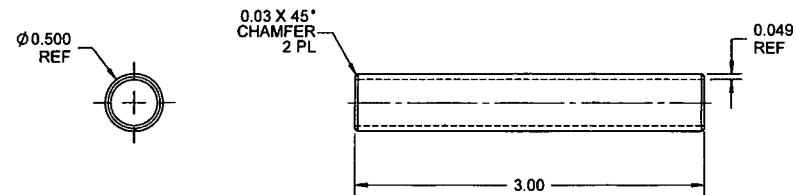
8 7 6 5 4 3 2 1



D3589-1 ARM



D3589-3 ARM GUIDE



D3589-5 LATCH GUIDE

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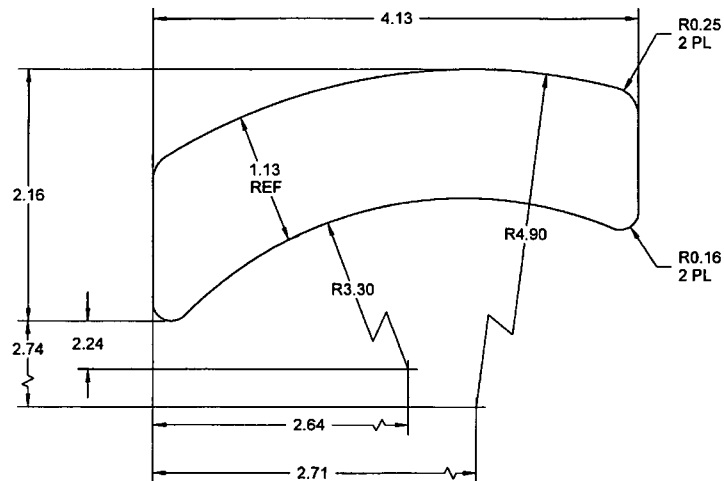
D3589-1/-3/-5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
 D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
 D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
 - D3589-3 = 0.01 lbs
 - D3589-5 = 0.06 lbs

RELEASED
 9/16/05

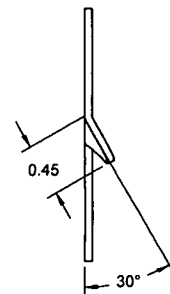
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 4 OF 8
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8 7 6 5 4 3 2 1



**D3589-7F AFT GUIDE PLATE
FLAT PATTERN**

**D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F**

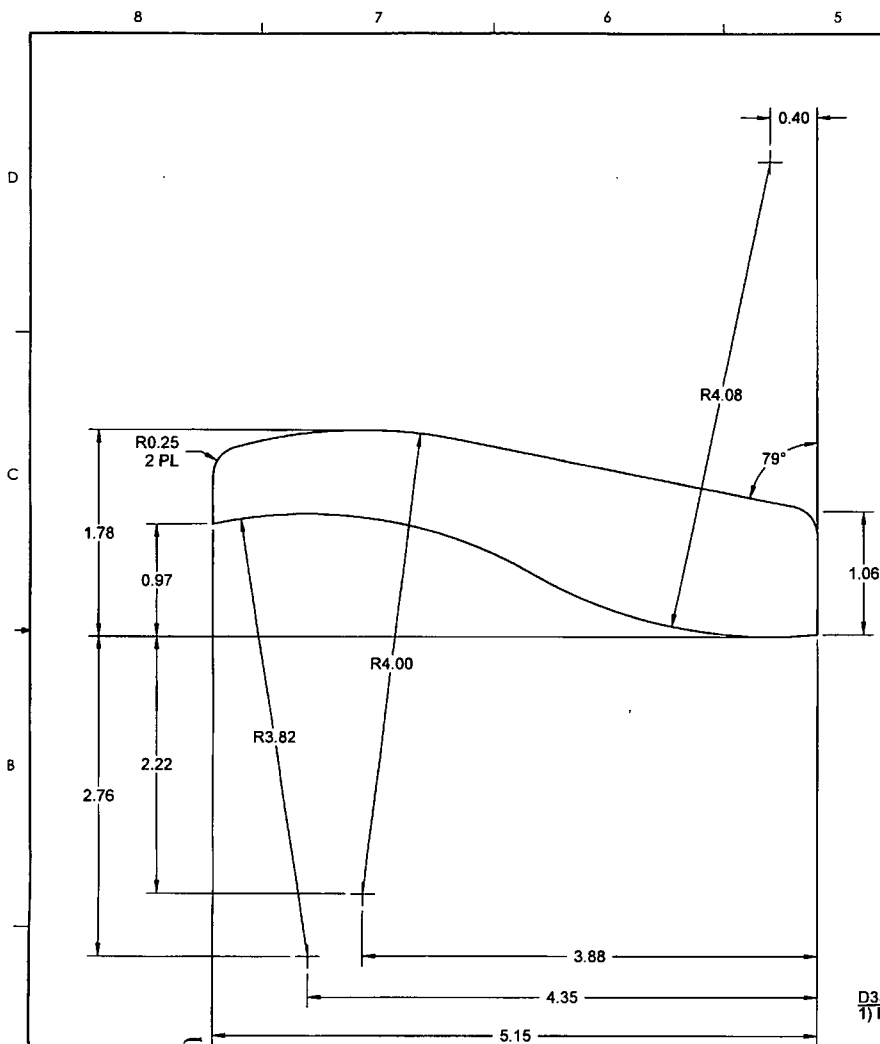


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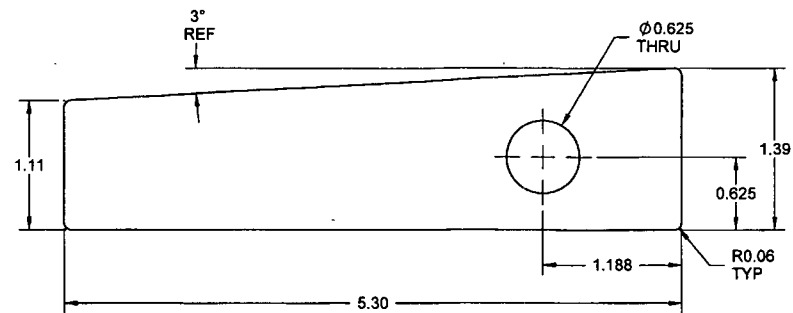
- D3589-7F NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.09 lbs

RELEASED
09/22/05

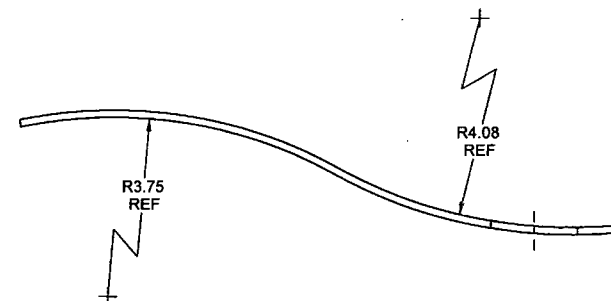
DESIGN	<i>A</i>	DART AEROSPACE LTD	
DRAWN	<i>A</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>DS</i>	D3589	SHEET 5 OF 8
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>HE</i>	LATCH ASSEMBLY	
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D3589-9 FORWARD GUIDE PLATE



D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN



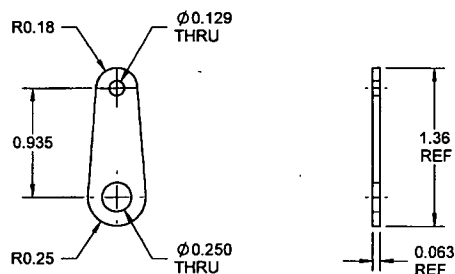
D3589-11 FORWARD GUIDE PLATE
(MAKE FROM D3589-11F)

- D3589-9/-11/-11F NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET,
 PER AMS 5513 OR AMS 5524,
 OR MIL-S-5059 (ANNEALED) 2B FINISH
 16 GAUGE (0.063 THICK),
 (REF. DART SPEC M304S16GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS
 OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.09 lbs EACH
 8) CONTROL SHAPE PER DT9021 TEMPLATE

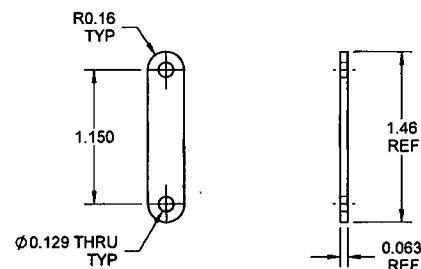
RELEASED
09/22/05/11P

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		FORWARD GUIDE PLATE	NTS
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D3589-13 LUG



D3589-15 LINK

NO. 45095
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D3589-13/-15 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

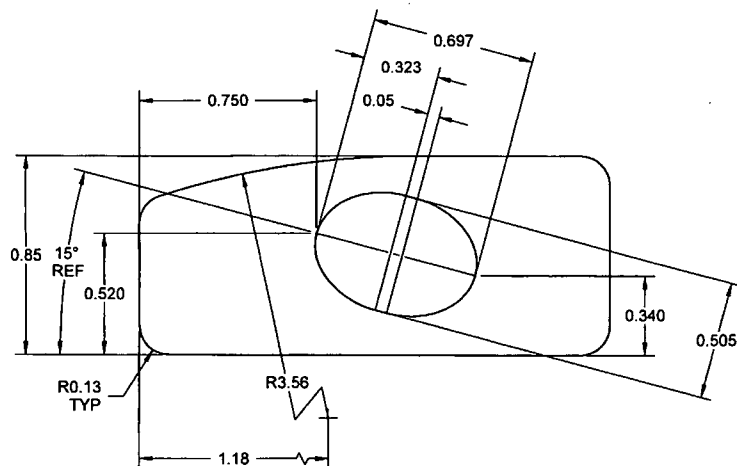
RELEASED
09/02/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3589	REV. B
MFG. APPR.			SHEET 7 OF 8
APPROVED		TITLE LATCH ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.06.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

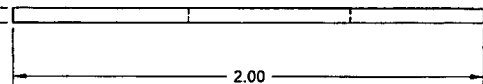
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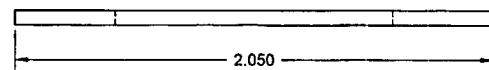
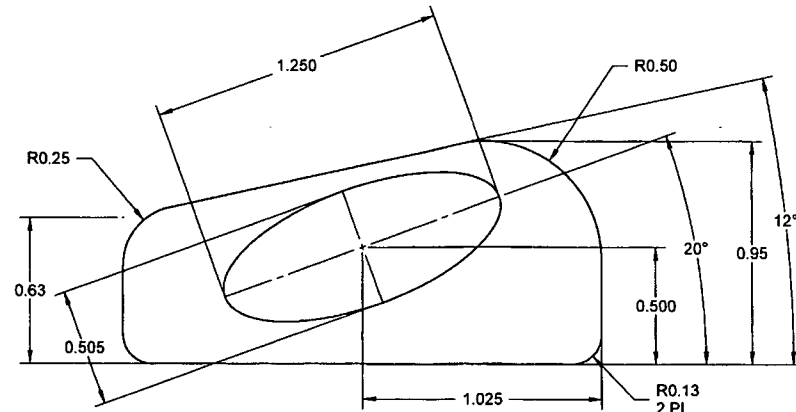
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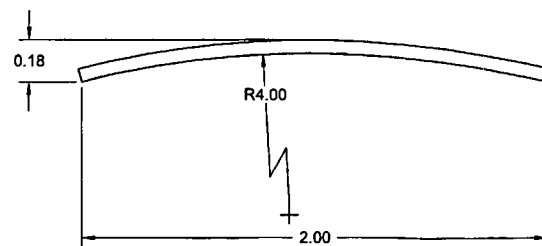
0.063
REF



D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN



D3589-19 AFT GUIDE PLATE
(MAKE FROM D3589-19F)

RELEASED
09/06/05/11/14

D3589-17/-19/-19F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET. PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.06.25

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3589	REV. B SHEET 8 OF 8
TITLE LATCH ASSEMBLY	SCALE NTS
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